

Tuesday, July 22, 2014 8:41:42 AM

122616

Page 1

Reference:

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 122616***122616***

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Item ID: D3608-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Upper Doubler
Start Date: 7/21/14 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 7/21/14 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: Sts05	0.00				4	AUG 18 2014		06 9-89
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MLJ 1408-18

MLJ 1408-18

DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 122616

122616

Parent Item: D3608-3

D3608-3

Parent Item Name: Upper Doubler

Start Date: 7/21/14

Required Date: 7/21/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-03-26 JLM
IPP Rev:B 08-10-15 preliminary issue DD verified by:EC
IPP Rev:C 08-12-11 rev.A as per dwg DD verified by:EC IPP
Rev:D 10.02.16 rev.B as per dwg DD verified by:EC IPP Rev:E
10.11.17 as per PC1 dwg DD verified by:EC IPP Rev:F 10.11.29 as
per revC dwg DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	315.2519	0.7392	3.112421			DAS 23 9-89
M304S20GA									**	3.5			14-08-16
304/316 .040 Sheet													

Location	Loc Qty	Loc Code
MAT020	315.2518948	
m126852	0.31	
m127454	26.1018948	
m128435	119.14	
m129128	6.5	
m129530	19.2	
m129845	144	

129845

DQA: _____ Date: _____



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Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			

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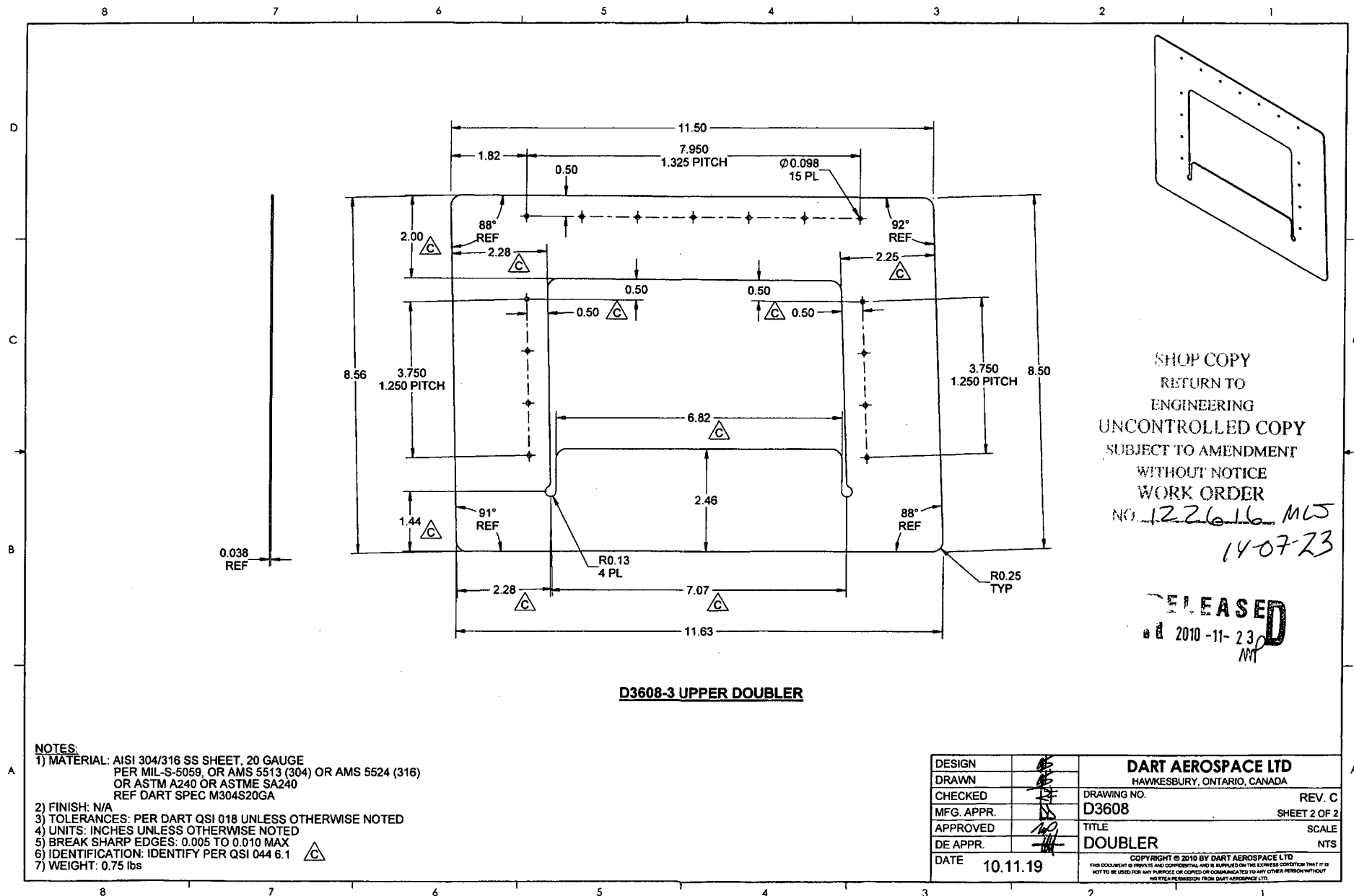
DART AEROSPACE LTD		Work Order:	122616
Description: Upper Doubler		Part Number:	D3608-3
Inspection Dwg: D3608 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.099"	✓		✓	Item 01
1.82	+/-0.030	1.82"	✓		✓	
0.50	+/-0.030	0.50"	✓		✓	
11.50	+/-0.030	11.50"	✓		✓	Item 8
7.950	+/-0.010	7.950"	✓		✓	
1.325	+/-0.010	1.325"	—		✓	
2.25	+/-0.030	2.25"	—		✓	
8.50	+/-0.030	8.50"	—		✓	
3.750	+/-0.010	3.750"	✓		✓	
1.250	+/-0.010	1.250"	—		✓	
6.82	+/-0.030	6.82"	—		✓	
2.46	+/-0.030	2.46"	—		✓	
7.07	+/-0.030	7.07"	—		✓	
11.63	+/-0.030	11.63"	—		✓	
2.28	+/-0.030	2.28"	—		✓	
1.44	+/-0.030	1.44"	—		✓	
8.56	+/-0.030	8.56"	—		✓	
2.00	+/-0.030	2.00"	—		✓	
0.040	+/-0.010	0.040"	—		✓	

Measured by: DAS 23 9/10		Audited by: DAS 38 9/10		Preliminary Approval:	
Date: 14-08-16		Date: 14/08/18		Date:	

Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ	
B	10.02.18	Dimensions updated per Dwg Rev B	KJ	
C	10.12.21	Dimensions updated per Dwg Rev C	KJ	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 122616 ML5
14-07-23

RELEASED
2010-11-23
MM

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASTM SA240
REF DART SPEC M304S20GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.75 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3608	REV. C
MFG. APPR.			SHEET 2 OF 2
APPROVED		TITLE DOUBLER	SCALE
DE APPR.			NTS
DATE	10.11.19	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	